

Date: Tuesday, 10/3/2006 2:50:15 PM  
User: Kim Johnston

## **Process Sheet**

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	N1 GEARBOX ACCESS PANEL KIT	
Job Number	28831				
Estimate Number	12503				
P.O. Number	N/A		Part Number	D3255041	
This Issue	10/3/2006	S.O. No. : N/A	Drawing Number	D3255 REV B	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type : LARGE FAB ASSY	Drawing Revision	B	
Previous Run	28124		Material	N/A	
Written By	<i>HJM</i>		Due Date	10/20/2006	
Checked & Approved By	<i>HJM 06 10 03</i>		Qty:	4	Um: Each
Comment	Est Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM				
<b>Additional Product</b>					
Job Number: 					
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>			
1.0	D32551	Panel 			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) <span style="float: right;">(4)</span> * Panel Batch: 28134 <i>CPL 07-01-10</i>					
2.0	D32553	Cap 			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) <span style="float: right;">(4)</span> ✓ Cap Batch: 21863 <i>CPL 07-01-10</i>					
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 			
Comment: LARGE FABRICATION RESOURCE 1 <span style="float: right;">(4)</span> ✓ 1-Weld as per Dwg D3255 A/R SS ROD Batch: M101134 <i>CPL 07-01-10</i>					
2-Grind Welds Flush					
4.0	QC5/9	WELD INSPECTION 			
Comment: WELD INSPECTION <i>No 7/01/10 (4)</i>					
5.0	POWDER COATING	POWDER COATING 			
Comment: POWDER COATING <i>M101601</i> Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <i>PFL 07/01/16</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/31/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 2:50:16 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 28831

Part Number: D3255041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml07/01/23

7.0 D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gasket

Batch: B28136 X 4

ml

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255

ml07/01/23 24

A/R 736

DOW CORNING ADHESIVE Batch: M10 3286

17/marzo 2009

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml07/01/23 4

B

10.0 PACKAGING 1

PACKAGING RESOURCE #1



PPP 412-705-617+

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/01/23 41

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ml07/01/23

Job Completion



07/01/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

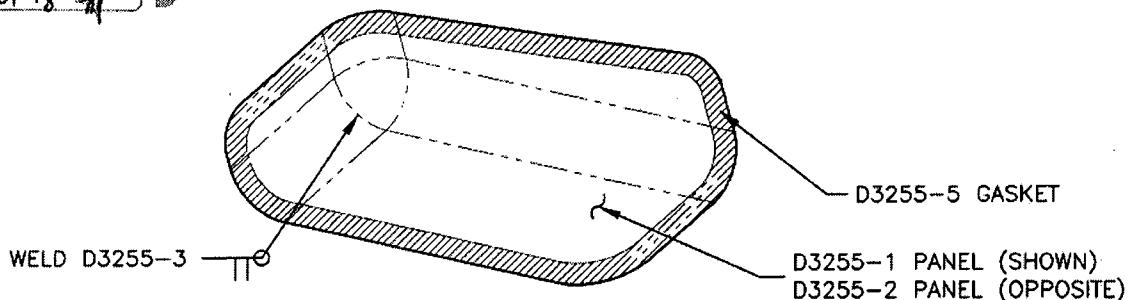
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

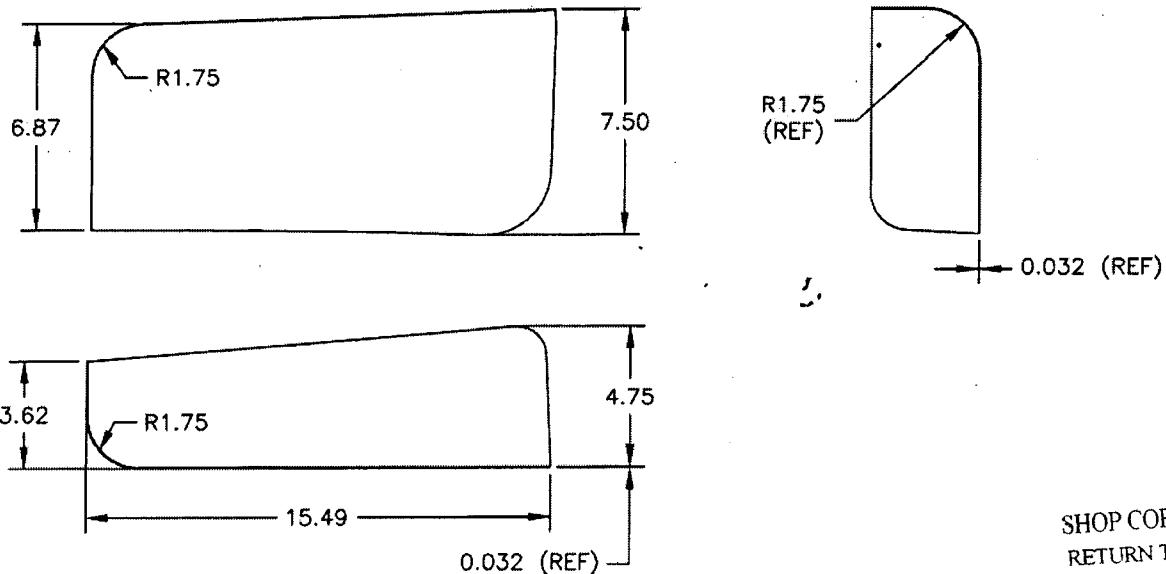
NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

**RELEASED**  
05.01.18 #

**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

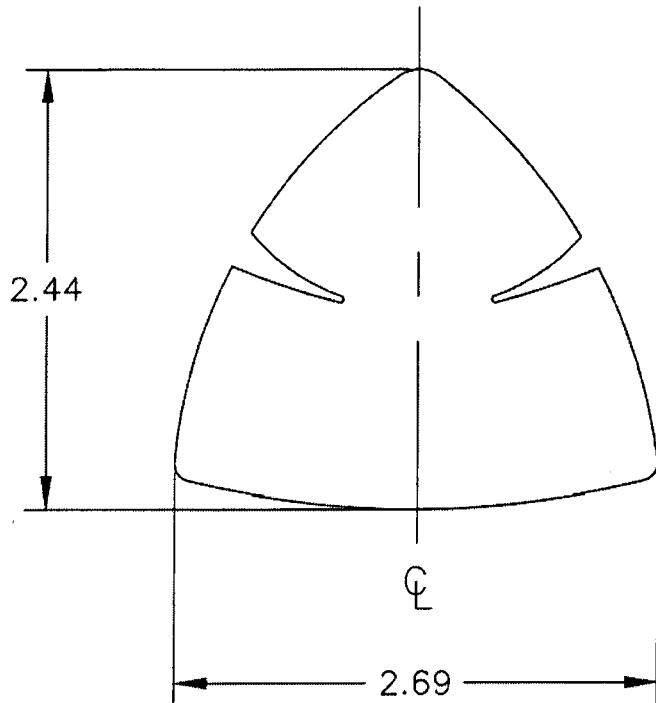
**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28831

**DART**

DESIGN RF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE	SCALE 1:1

**RELEASED**  
05-01-18 *[Signature]*

**D3255-3 CAP**  
FORM TO FIT D3155-1/-2

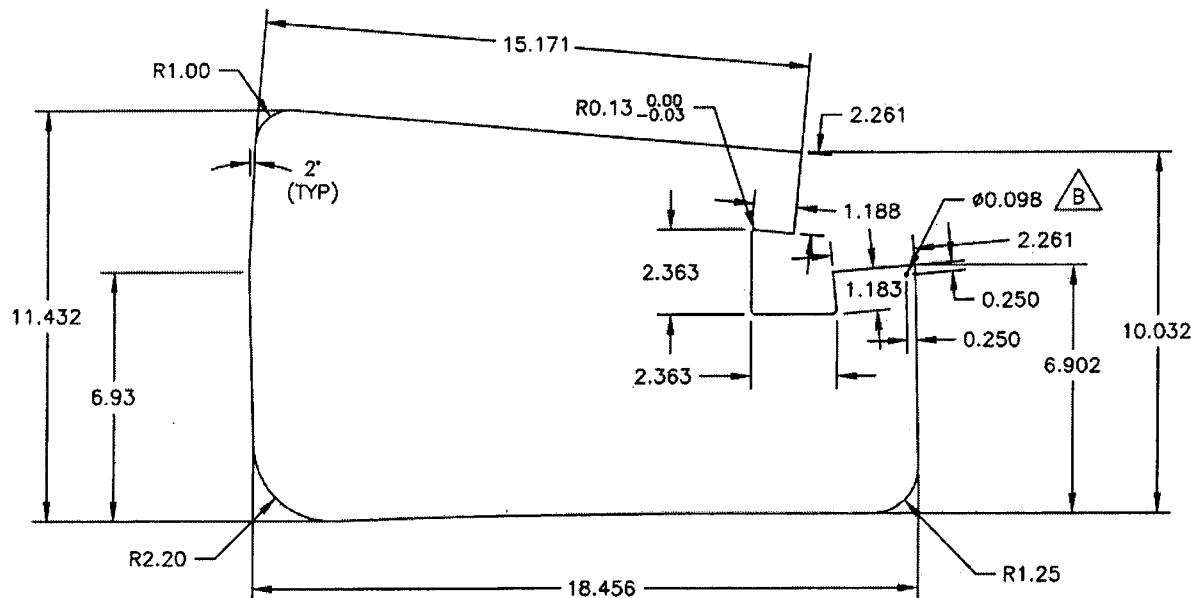
**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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WORK ORDER  
NO. 28831

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

**RELEASED**  
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SUBJECT TO AMENDMENT

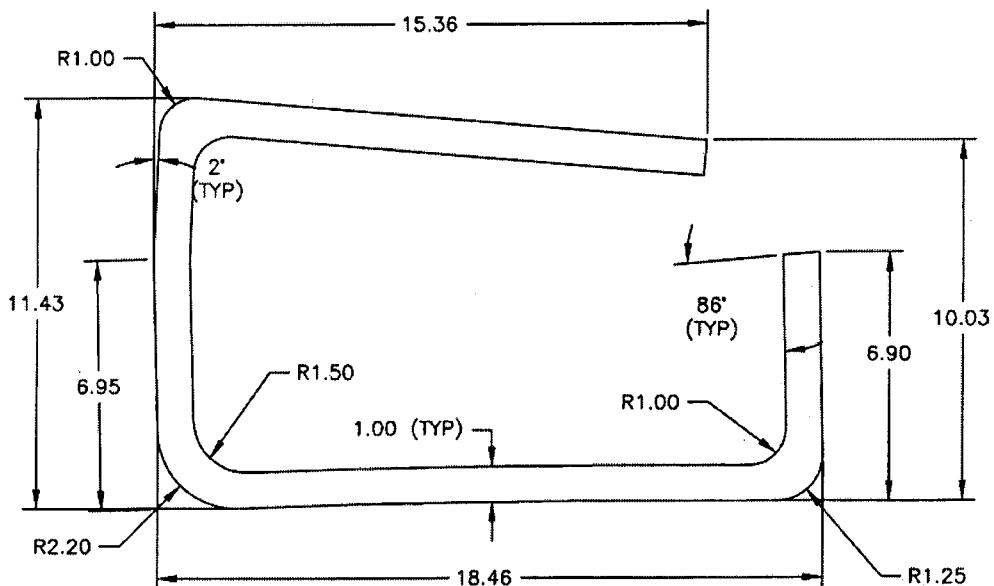
WITHOUT NOTICE

WORK ORDER

NO. 28831

**DART**

DESIGN <i>TP</i>	DRAWN BY <i>TP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LP</i>	APPROVED <i>TP</i>	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

**RELEASED**  
DS-0118 *TP***D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE  
WORK ORDER  
NO. *28831*